

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017985**Date Inspected:** 07-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

ZPMC SHIP # 19 (10CW)

This QA Inspector along with Mr. Manoj Prabhune photographed and documented at various locations on OBG 10CW prior to the shipment of (Voyage 6) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 10CW (Panel Point 91.5 thru Panel point 94.5) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 10CW – PP 91.5, PP 92.5, PP 93.5and PP 94.5.
2. Corner Assembly – Crossbeam side of segment 10CW – PP 92 to PP 94.
3. Longitudinal Diaphragm - Crossbeam side of segment 10CW – PP 92 to PP 94.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 10CW – PP 92 to PP 94.
5. Sea fasteners- 10CW – PP 92 to PP 94.
6. Chevron Diagonal members (upper and lower) – Bike path side of segment 10CW – PP 92 to PP 94.
7. Longitudinal Diaphragm – Bike path side of segment 10CW – PP 92 to PP 94.
8. Corner Assembly – Bike path side of segment 10CW – PP 92 to PP 94.
9. Truss post – Bike path side of segment 10CW – PP 92 to PP 94.

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## WELDING INSPECTION REPORT

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### OBG # TRIAL ASSEMBLY YARD (11CW-11DW)

This QA inspector along with QA inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the U-rib to verify the offset. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11CW to Segment 11DW

### OBG # TRIAL ASSEMBLY YARD (11CE-11DE)

This QA inspector along with QA inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the U-rib to verify the offset. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11CE to Segment 11DE

This QA Inspector randomly observed the following work in progress:

### OBG # TRIAL ASSEMBLY YARD (11DW-11EW)

The QA inspector observed the welding operation per the SMAW process on weld joint no. 010 in the (3G) vertical position on edge panel piece mark no. OBW11A. The location was the transverse splice weld joining segment 11DW and 11EW. The welder ID was 040611. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1.

For additional information please reference the pictures below:

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations were reported on this date.

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Manikandan,Murugan	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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